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D3912-1

Job Sheet 205811



Part No: D3912-1

Job Qty: 30 pcs

Part Name: Eyebolt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/20

Job Tracking No:

Due Date: 2/3/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	30 pcs	2/3/20	2/3/20	1.00	21.43	Doosan - 1		
110	QC 2	30 pcs	2/3/20	2/3/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
120	QC 8	30 pcs	2/3/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
130	Packaging 3-1 - Stock - B4B	30 pcs	2/3/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B

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DAS
80
9-89

ST056F

FEB 10 2020

					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140 QC 21 - SA	30 pcs	2/3/20	0.00	0.00	QC 21 - SA - 21 ✓	ST 056 F
					QC 21 - SA - 70	FEB 10 2020
					QC 21 - SA - 53	

Part Op 100 - (Doosan Lathe) TURN AS PER FOLIO FA871AND DWG Prog Rev: 6 Deburr as required
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	8.4000 (28 ea)	100-Doosan - 1	S250470

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	8	4	0

Handwritten calculations and notes:

- 7.260 (circled)
- 0.1242 ea (circled)
- ~~7.226~~

Handwritten notes on the right margin:

- 4'
- 4'
- 8 7/8
- 7.260

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.1305	
2	Eyebolt	0.700Inches ± 0.010	0.710 0.690	.7	
3	Eyebolt	0.500Inches ± 0.010	0.510 0.490	.5007	
4	Eyebolt	0.900Inches ± 0.030	0.930 0.870	.9	
5	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.1305 .14	
6	Eyebolt	45.0Degrees ± 0.5	45.5 44.5	45°	
7	Eyebolt	0.220Inches ± 0.030	0.250 0.190	.221	
8	Eyebolt	0.750Inches ± 0.030	0.780 0.720	.75	
9	Eyebolt	0.970Inches ± 0.010	0.980 0.960	.967	
10	Eyebolt	1.720Inches ± 0.030	1.750 1.690	1.718	
11	Eyebolt	1.200Inches ± 0.030	1.230 1.170	1.202	
12	Eyebolt	0.6250Inches ± 0.0100	0.6350 0.6150	.627	
13	Eyebolt	2.230Inches ± 0.030	2.260 2.200	2.231	
14	Eyebolt	0.130Inches ± 0.030	0.160 0.100	R/8	Radius
15	Eyebolt	0.015Inches ± 0.010	0.025 0.005	R.015	Radius
16	Eyebolt	0.625Inches ± 0.010	0.635 0.615	.63	
17	Eyebolt	0.650Inches ± 0.010	0.660 0.640	.647	
18	Eyebolt	1.100Inches ± 0.010	1.110 1.090	1.098	
19	Eyebolt	0.440Inches ± 0.030	0.470 0.410	.4405	
20	Eyebolt	0.130Inches ± 0.030	0.160 0.100	R/8	Radius
21	Eyebolt	1.000Inches ± 0.030	1.030 0.970	1.005	
22	Eyebolt	0.250Inches ± 0.030	0.280 0.220	.249	
23	Eyebolt	0.880Inches ± 0.030	0.910 0.850	.89	
24	Eyebolt	0.110Inches ± 0.030	0.140 0.080	.112	
25	Eyebolt	0.719Inches + 0.010 - 0.000	0.729 0.719	.726	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					